

Work Order ID 77029

77029

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November-24-11 3:38:38 PM

Item ID: D3793-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 24/11/2011 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
341.040 Deburr if necessary
1312-1-4
(13)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control
1312-1-4

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control
512/01/05
(13)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00				(13)			
130									
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								

SB 12/01/09

140	QC5- Inspect part completeness to step on W/O	0.00				(43)			
140									
QC	Memo	0.00							
Quality Control									

8/12/01/09

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:00 OVEN TEMPERATURE: 3200 F FINISH TIME: 3:30								

13X2 m 12/04/11

m118489

3200 F

3:30

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						13	BL	12-1-12	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FD-2</u>	0.00							
170						13	BL	12-1-12	
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/16 *[Signature]*
 12-01-12

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Picklist Print

November-24-11 3:38:42 PM

Page 1

Work Order ID: 77029

77029

Parent Item: D3793-1

D3793-1

Parent Item Name: Wearshoe

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	261.8795	0.5902	7.455158			

M304S20GA

304/316 .040 Sheet

1312-1-4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	261.8795	
116623	0.2	
117550	4.363	
117933	27.3442	
118400	25.6723	
118964	36.5	
119346	167.8	

119346

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77029
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	189	✓		✓ RBZ	
0.300 x 0.300	+/-0.010	300 x 302	✓		✓	
1.885	+/-0.010	1.890	✓		✓	
2.000	+/-0.010	2.001	✓		✓	
5.00	+/-0.030	5.00	✓		T RB1	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.066	+/-0.010	14.066	✓		T	
18.983	+/-0.010	18.983	✓		T	
23.900	+/-0.010	23.900	✓		T	
27.400	+/-0.010	27.400	✓		T	
29.400	+/-0.010	29.400	✓		T	
32.900	+/-0.010	32.900	✓		T	
0.040	+/-0.010	0.036	✓		V	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 12-1-4	Date: 12/04/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	JA

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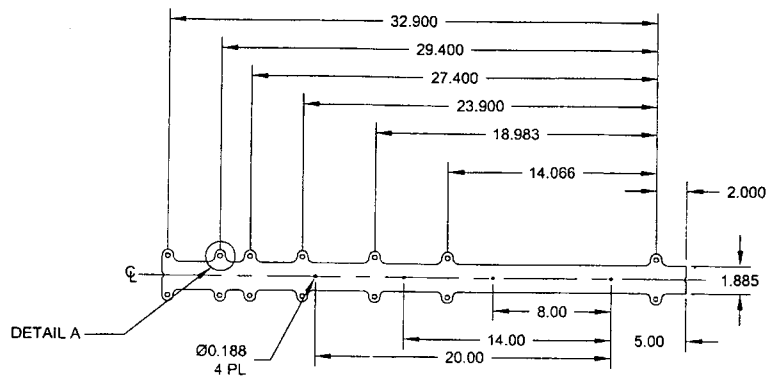
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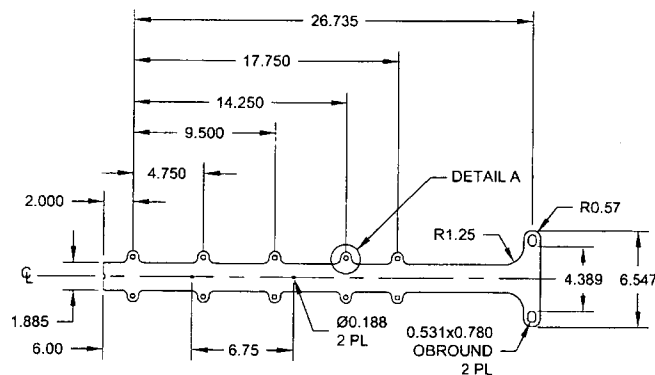
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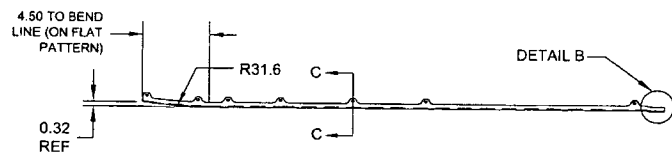
C



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

77029 M.C.J
11/11/24

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3793
REV. A
SHEET 1 OF 2
TITLE WEARSHOE
SCALE NTS

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8 7 6 5 4 3 2 1

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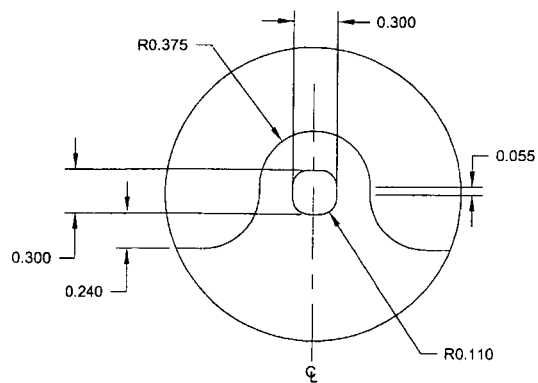
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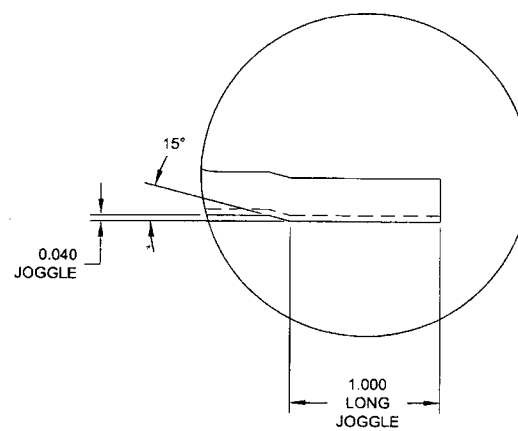
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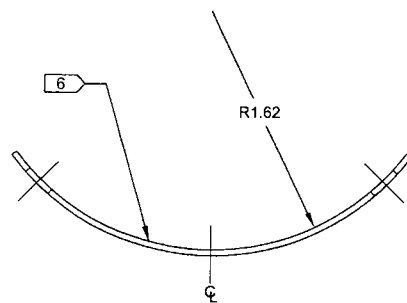
27029



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	IS	D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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